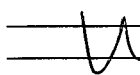
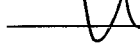


Date: Tuesday, 28/11/2006 10:11:52 AM
 User: Linda Lacelle

Process Sheet

Customer	: CC-DAR01 Dart Aerospace Ltd.	Drawing Name	: D26662
Job Number	: 29720		
Estimate Number	: 10804		
P.O. Number	: N/A	Part Number	: D26662
This Issue	: 28/11/2006 S.O. No. : N/A	Drawing Number	: RTN 531
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : MACHINED PARTS	Drawing Revision	: N/A
Previous Run	: 29718	Material	: N/A
Written By	: 	Due Date	: 05/12/2006
Checked & Approved By	: 	Qty:	1 Um: Each
Comment	:		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	QC5	INSPECT WORK TO CURRENT STEP



Comment: INSPECT RTN 531



06/11/28 ①

2.0	D26662	Saddle, RH, Fwd, Aft, In
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
 Saddle, RH, Aft, Out
 ORIGINAL B/N 24850



06/11/28 ①

3.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1
 ID & STK
 USING NEW B/N



06/11/28 ①

4.0	QC21	FINAL INSPECTION/W/O RELEASE
-----	------	------------------------------



Comment: FINAL INSPECTION/W/O RELEASE



07/01/19 ①

Job Completion



07.01.19

Date: Monday, 11/28/2005 10:27:11 AM
User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : SADDLE, INBOARD, RS, 206
Job Number : 24850	
Estimate Number : 10821	
P.O. Number : <u>N/A</u>	Part Number : D26662
This Issue : 11/28/2005 S.O. No. : <u>N/A</u>	Drawing Number : D2666 REV. B
Prsht Rev. : NC	Project Number : N/A
First Issue : <u>N/A</u> Type : MACHINED PARTS	Drawing Revision : B
Previous Run : 24582	Material : <u>N/A</u>
Written By : <u>See comment below</u>	Due Date : 12/5/2005 Qty: 12 Um: Each
Checked & Approved By : <u>See comment below</u>	
Comment : Est: C 00.11.01 Removed P/O for Powder Coat - in house processEC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D6101001	7075-T7351 2X6X6.25
-----	----------	---------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 12.0000 Each(s)

7075-T7351 2X6X6.25

Issue material from stock:

Cut Size 2.0 x 6.25 X 6.0

Grain Along Long 6.0 Length

Batch No: B24890 En 06/01/07 12

2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
-----	-------	--------------------------------



Comment: HAAS CNC VERTICAL MACHINING #1

Program batch number.

1-Inspect part number and batch number are programmed correctly. MS 06/01/07

2-Fixturing W/O No. N/A

3-Fixturing Inspection last completed on 06/01/07 by Jmk

4-Machine Step No 1 of Folio and visually inspect as per attached Dimension Sheet

5-Machine Step No 2 of Folio and visually inspect as per attached Dimension Sheet

6-Machine Step No 3 of Folio and visually inspect as per attached Dimension Sheet

7- Deburr En 06/01/09

3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
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Comment: CONVENTIONAL MILLING MACHINE

Machine Keyway and inspect per attached dimension sheet

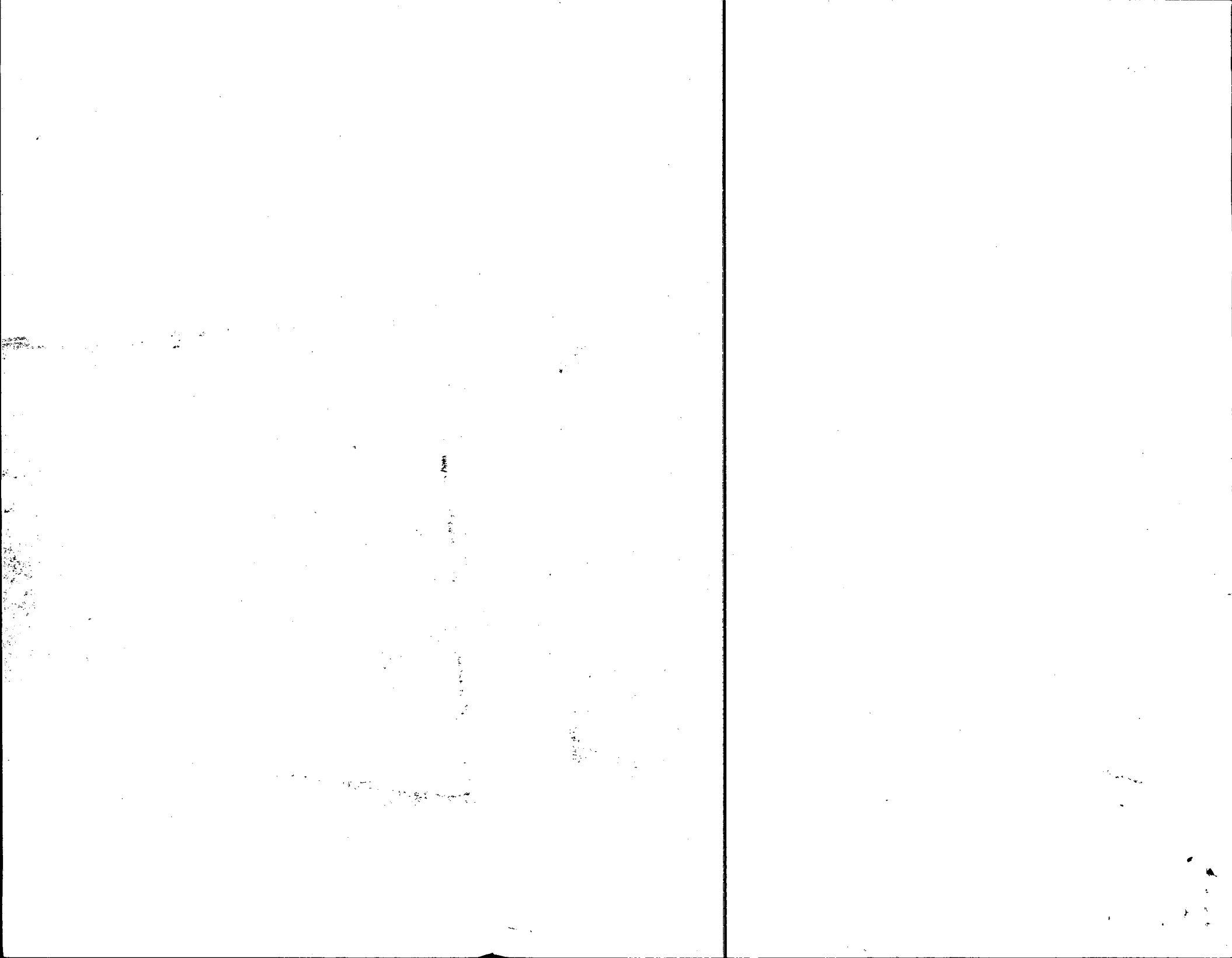
En 06/01/14

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

En 06/01/14



Date: Monday, 11/28/2005 10:27:11 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE, INBOARD, RS, 206

Job Number: 24850

Part Number: D26662

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

J.G

06/01/14

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

SAD

06801817

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

MM

06 01 16

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

C206/01/17

(12)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 363

C206/01/17

12

10.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

545 06/01/18

(12)

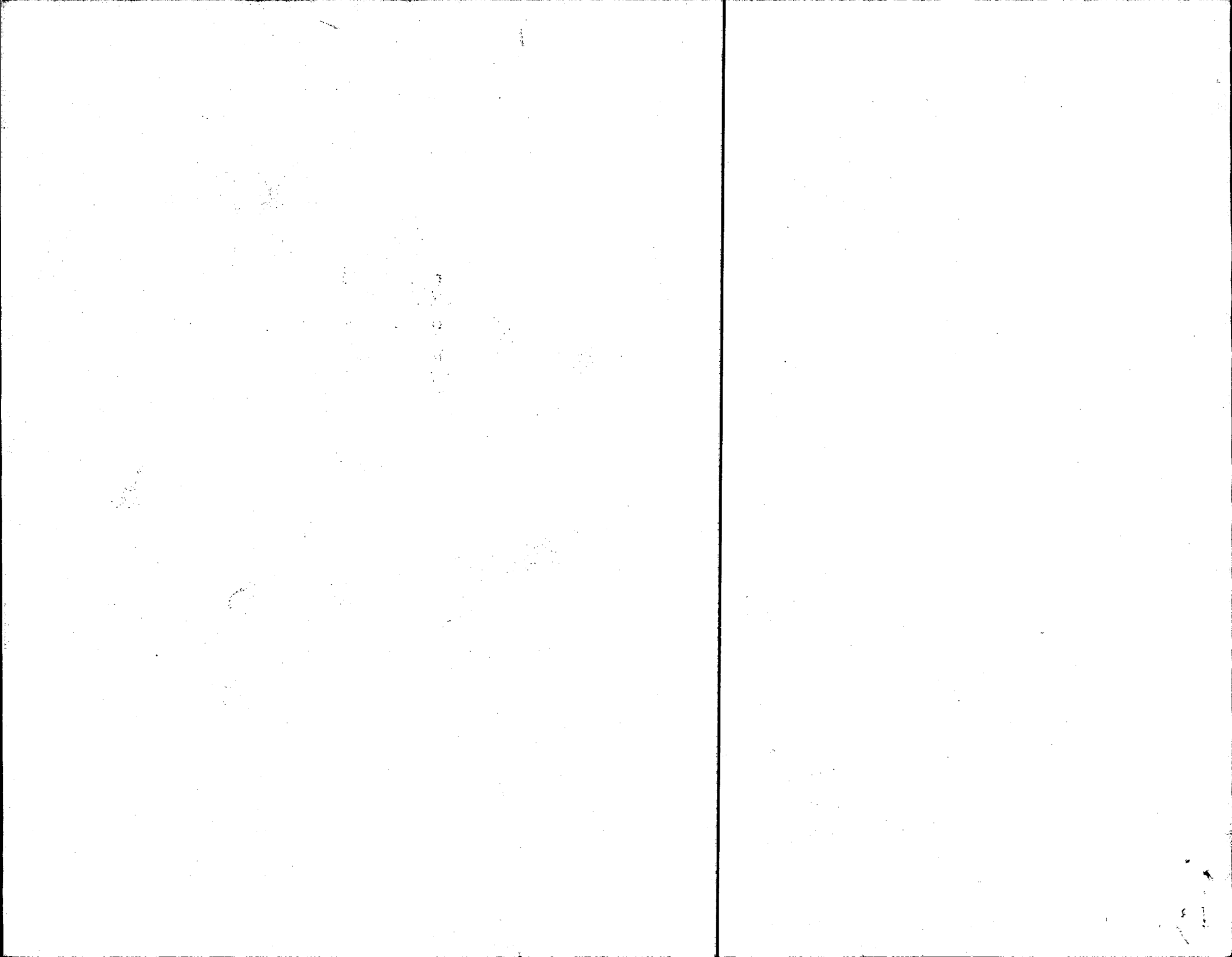
DP

06/01/18

(12)

Job Completion





DART AERO SPACE LTD		Work Order:	24850
Description: 203 Saddle, Inboard, Right side		Part Number:	D2666-2
Inspection Drawing: D2666 Rev. B		Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing D2666 Rev. B and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
	0.100	0.140		0.126	0.125	0.125	0.127		
	0.100	0.140		0.127	0.127	0.127	0.127		
	0.100	0.140		0.127	0.120	0.117	0.120		
D	0.210	0.230		0.224	0.224	0.224	0.224		
E	1.245	1.255		1.250	1.250	1.250	1.250		
F	1.245	1.255		1.250	1.250	1.250	1.250		
G	5.990	6.010		6.000	6.002	6.002	6.002		
H	0.510	0.515		0.512	0.512	0.512	0.512		
I	1.674	1.684		1.679	1.677	1.678	1.678		
J	2.495	2.505		2.499	2.499	2.500	2.500		
K	0.257	0.262	DT8683	0.261	0.258	0.258	0.258		
L	0.312	0.317	DT8686	0.314	0.314	0.314	0.314		
M	0.235	0.240		0.239	0.239	0.239	0.239		
N	0.100	0.140		0.120	0.120	0.122	0.123		
O	0.540	0.560		0.549	0.551	0.552	0.550		
P	0.490	0.510		0.502	0.503	0.505	0.505		
Q	3.609	3.619		3.610	3.610	3.610	3.610		
R	2.470	2.510		2.491	2.494	2.493	2.494		
S	0.240	0.270		0.254	0.253	0.253	0.253		
T	0.100	0.180		0.142	0.142	0.141	0.140		
U	0.313	0.318	DT8686	0.318	0.318	0.318	0.318		
V	1.125	1.145		1.135	1.133	1.135	1.136		
W	1.565	1.585	DT8695 A/B	✓	✓	✓	✓		
X									
Y									
Z									
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	<i>me</i>	Audited by:	<i>J.G</i>
Date:	06/01/07 / 06/01/14	Date:	06/01/14

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.10	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686 & DT8695 A/B	KJR/RF	<i>RF</i>

DSI AEROSPACE LTD	Work Order	24850
Description: 206 Saddle, Inboard, Right side	Part Number	D2666-2
Inspection Dwg: D2666 Rev. B		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2666 Rev. B and record below:

Dim				Recorded Actual Dimensions				By	Date
	Min	Max	Go/No Go Gauge	#5	#6	#7	#8		
A	0.100	0.140		0.125	0.128	0.126	0.126		
B	0.100	0.140		0.129	0.127	0.128	0.123		
C	0.100	0.140		0.120	0.119	0.121	0.117		
D	0.210	0.230		0.224	0.224	0.224	0.220		
E	1.245	1.255		1.250	1.250	1.250	1.246		
F	1.245	1.255		1.250	1.250	1.250	1.246		
G	5.990	6.010		6.002	6.002	6.002	6.004		
H	0.510	0.515		0.512	0.512	0.512	0.512		
I	1.674	1.684		1.678	1.678	1.678	1.679		
J	2.495	2.505		2.500	2.500	2.500	2.500		
K	0.257	0.262	DT8683	0.258	0.258	0.258	0.258		
L	0.312	0.317	DT8686	0.314	0.314	0.314	0.314		
M	0.235	0.240		0.237	0.237	0.237	0.237		
N	0.100	0.140		0.122	0.122	0.119	0.120		
O	0.540	0.560		0.550	0.551	0.551	0.545		
P	0.490	0.510		0.502	0.502	0.501	0.500		
Q	3.609	3.619		3.610	3.610	3.611	3.613		
R	2.470	2.510		2.492	2.493	2.493	2.490		
S	0.240	0.270		0.253	0.253	0.253	0.253		
T	0.100	0.180		0.142	0.143	0.146	0.146		
U	0.313	0.318	DT8686	0.318	0.318	0.318	0.318		
V	1.125	1.145		1.136	1.136	1.135	1.136		
W	1.565	1.585	DT8695 A/B						
X									
Y									
Z									
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	EP
Date:	06/01/09

Audited by:	J.G
Date:	06/01/14

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.10	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686 & DT8695 A/B	KJ/RF	RF

RELEASED
3.06.18 RF

AEROSPACE LTD		Work Order:	24850
Description: 266 Saddle, Inboard, Right side		Part Number:	D2666-2
Drawing: D2666 Rev. B		Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing D2666 Rev. B and record below:

Dim	Recorded Actual Dimensions				By	Date
	Min	Max	Go/No Go Gauge			
A	0.100	0.140		0.125		
B	0.100	0.140		0.128		
C	0.100	0.140		0.115		
D	0.210	0.230		0.220		
E	1.245	1.255		1.248		
F	1.245	1.255		1.247		
G	5.990	6.010		6.002		
H	0.510	0.515		0.512		
I	1.674	1.684		1.678		
J	2.495	2.505		2.500		
K	0.257	0.262	DT8683	0.259		
L	0.312	0.317	DT8686	0.312		
M	0.235	0.240		0.238		
N	0.100	0.140		0.119		
O	0.540	0.560		0.549		
P	0.490	0.510		0.499		
Q	3.609	3.619		3.612		
R	2.470	2.510		2.495		
S	0.240	0.270		0.250		
T	0.100	0.180		0.140		
U	0.313	0.318	DT8686	0.318		
V	1.125	1.145		1.135		
W	1.565	1.585	DT8695 A/B			
X						
Y						
Z						
AA						
AB						
AC						
AD						
AE						
AF						
AG						
AH						
Accept/Reject						

Measured by: <u>En</u>	Audited by: <u>06/01/14 J.G.</u>
Date: <u>06/01/09</u>	Date: <u>06/01/14</u>

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.10	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686 & DT8695 A/B	KJ/RF	<u>RF</u>

RELEASED
03.06.18 RF